

Work Order ID 79045

79045

Page 1

January-18-12 3:55:35 PM

Item ID: D3684-049 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: AFT LEG ASS'Y
 Start Date: 18/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 01/02/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 12/01/18 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3684	Rev D

100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									

110	Small Fab	0.00							
110									
Small Fab	Memo	0.00							
Small Fab	1-Use anti-seize compound Tectly 502c Class 2 Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684 M 111791								
	2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684 ***Ensure holes for AN3C Bolts are free of sealant. Torque Fastners as per Dwg D3684 M 119508								

(4) FF 12-04-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		517-4/12/12		(74)			
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>200</u> Memo	0.00 0.00				12/4/12	51	4	
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/4/15 [Signature]

12-04-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

January-18-12 3:55:38 PM

Page 1

Work Order ID: 79045

79045

Parent Item: D3684-049

D3684-049

Parent Item Name: AFT LEG ASS'Y

Start Date: 18/01/2012

Required Date: 01/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC IPP
 REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C12A		Purchased	No			110	Each	40.0000	2	8			
AN3C12A													
Bolts													

Location	Loc Qty	Loc Code
ST351 120423	40	
117514	4	
118112	5	
118422	8	
118451	22	
119510	1	

D3688-3		Manufactured	No			110	Each	7.0000	1	4			
D3688-3													
STUD													

Location	Loc Qty	Loc Code
GA 79093	7	
69625	2	
73459	5	

D3689-1		Manufactured	No			110	Each	8.0000	1	4			
D3689-1													
SLEEVE													

Location	Loc Qty	Loc Code
GA 78907	1	
70858	1	
ST061 80362	7	
72117	7	

W/O:		WORK ORDER CHANGES					
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Work Order ID: 79045

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Parent Item: D3684-049

D3684-049

Parent Item Name: AFT LEG ASS'Y

Start Date: 18/01/2012

Required Date: 01/02/2012

Start Qty: 4.00

Required Qty: 4.00

D3691-1 Manufactured No

110 Each 7.0000 1 4

D3691-1

STUD

80363

**

4 (4) FF 12-04-03

Location

Loc Qty

Loc Code

GA

7

62181

7

D3692-1 Manufactured No

110 Each 121.0000 4 16

D3692-1

SPACER

**

(4) FF 12-04-03

Location

Loc Qty

Loc Code

ST061

121

51467

21

73232

100

D3693-1 Manufactured No

110 Each 9.0000 1 4

D3693-1

Rod End Bearing

**

(4) FF 12-04-03

Location

Loc Qty

Loc Code

GA

5

78118

5

ST

4

73505

4

4

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Page 3

Work Order ID: 79045

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Parent Item Name: AFT LEG ASSY

79045

D3684-049

Start Date: 18/01/2012

Required Date: 01/02/2012

Start Qty: 4.00

Required Qty: 4.00

MS21043-3

Purchased

No

110

Each

1,243.000

2

8

MS21043-3

Nut

**

(4) FF 12-04-03

Location

Loc Qty

Loc Code

FG

72

103691

72

ST300

632

119901

632

ST301

539

118077

2

118614

441

118686

30

119758

66

8

NAS509-12C

Purchased

No

110

Each

11.0000

1

4

NAS509-12C

Nuts

**

(4) FF 12-04-03

Location

Loc Qty

Loc Code

ST279

120422

11

112453

11

3

1

NAS509L12C

Purchased

No

110

Each

16.0000

1

4

NAS509L12C

Nuts

**

(4) FF 12-04-03

Location

Loc Qty

Loc Code

ST279

120632

16

112314

6

112828

10

2

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

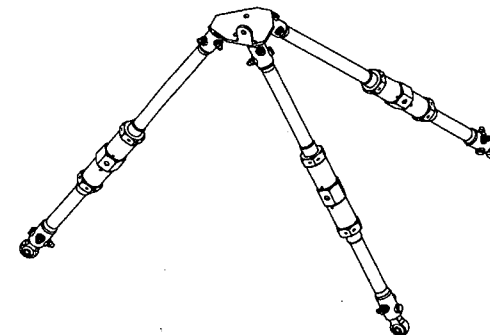
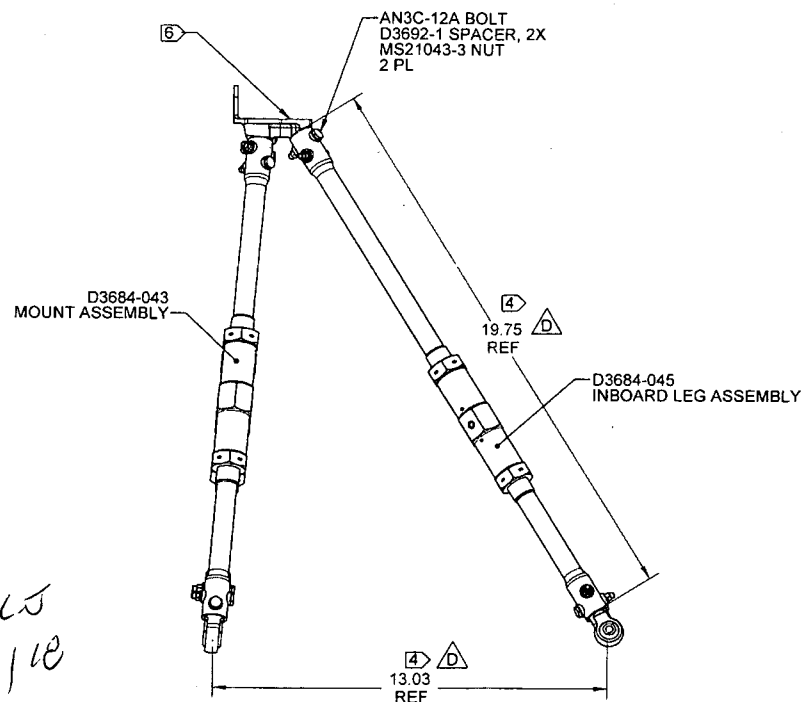
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3684-041	TRIPOD MOUNT ASSEMBLY
2	1	D3684-043	MOUNT ASSEMBLY
3	1	D3684-045	INBOARD LEG ASSEMBLY
4	4	D3692-1	SPACER
5	2	AN3C-12A	BOLT
6	2	MS21043-3	NUT



UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 79045-4.65
 12/01/10

RELEASED
 2010-03-15
 JWP

D3684-041 TRIPOD MOUNT ASSY

- NOTES:**
- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 2) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 3) IDENTIFICATION: NONE
 - 4) DIMENSIONS SHOWN ARE WHEN D3688-1/-3/-5 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
 - 5) WEIGHT: 9.9 lbs
 - 6) ASSEMBLE D3684-045 WITH D3684-043 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT
 - 7) ASSEMBLY SHOWN FOR REF ONLY, -041 IS PACKAGED UNASSEMBLED

D	13.03 WAS 13.10 (ZN B5-1); 19.75 WAS 19.87 (ZN C4-1); 19.40 WAS 19.52 (ZN C6-2); 17.15 WAS 17.27 (ZN C4-2); 19.85 WAS 20.24 (ZN B5-2); 20.96 WAS 21.09 (ZN C5-3); 20.62 WAS 20.74 (ZN C5-4); 18.37 WAS 18.49 (ZN C6-5)	RF	10.03.03
C	NOW ASSEMBLED USING SEALANT (ZN A8-1, D6-1, A8-2, D4-2, A8-3, B4-3, A8-4, B4-4, A8-5, B5-5); ASSEMBLY NOW SHOWN FOR REF ONLY (ZN A8-1, A4-1)	RF	08.12.15
B	19.52 WAS 19.50 (ZN C6-2); 9.20 WAS 9.70 (ZN C6-2); 20.74 WAS 21.24 (ZN C5-4); 9.95 WAS 8.98 (ZN D5-5); MODIFIED PER PROTOTYPE INSTALLATION; REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3684	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
DATE	10.03.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

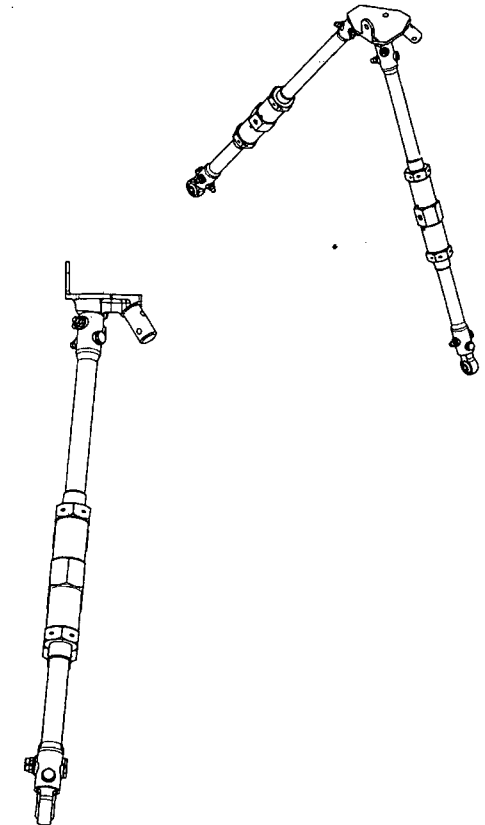
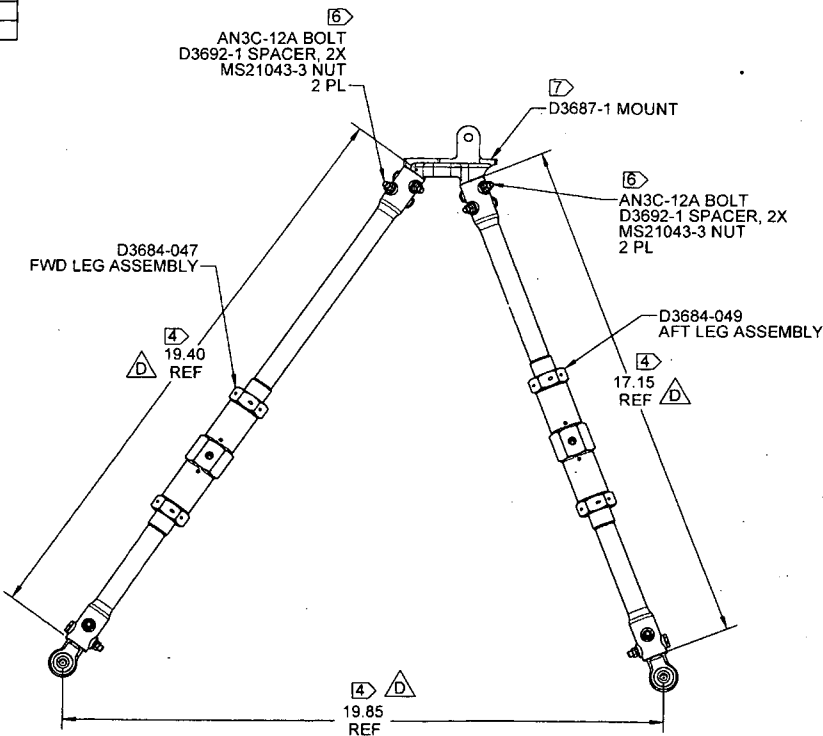
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NOTE: Date & initial all entries

79015

ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D3684-043	MOUNT ASSEMBLY
2	1	D3687-1	MOUNT
3	1	D3684-047	FWD LEG ASSY
4	1	D3684-049	AFT LEG ASSY
5	8	D3692-1	SPACER
6	4	AN3C-12A	BOLT
7	4	MS21043-3	NUT



D3684-043 MOUNT ASSEMBLY

RELEASE
2010-03-15

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-043 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 6.6 lbs
- 6) TORQUE FASTENERS TO 20-25 in-lbs
- 7) ASSEMBLE D3684-047 & D3684-049 WITH D3687-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. D
DRAWN	RF		
CHECKED		DRAWING NO. D3684	SHEET 2 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		TRIPOD MOUNT ASSY	NTS
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	10.03.03		

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

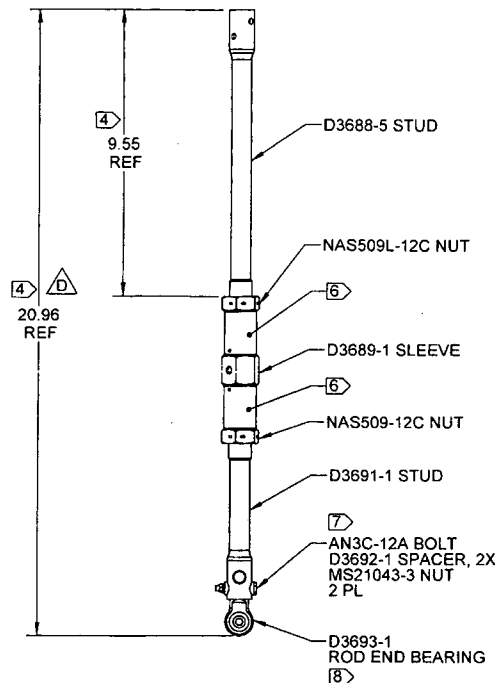
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NOTE: Date & initial all entries

79045

ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D3684-045	INBOARD LEG ASSEMBLY
2	1	D3688-5	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT






D3684-045 INBOARD LEG ASSEMBLY

RELEASED
2010-03-15

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-045
USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSION SHOWN IS WHEN D3688-5 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.1 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2'
SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3684	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
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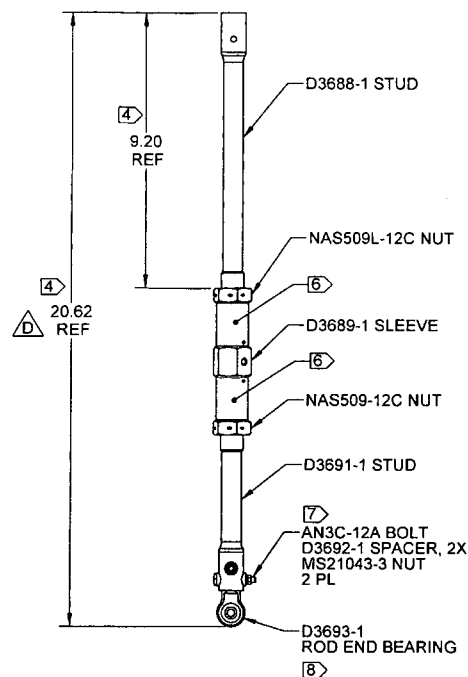
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ITEM	QTY -047	PART NUMBER	DESCRIPTION
1	X	D3684-047	FWD LEG ASSEMBLY
2	1	D3688-1	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



D3684-047 FWD LEG ASSEMBLY

RELEASED
2010-03-15

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-1 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.09 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

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CHECKED		DRAWING NO.	REV. D
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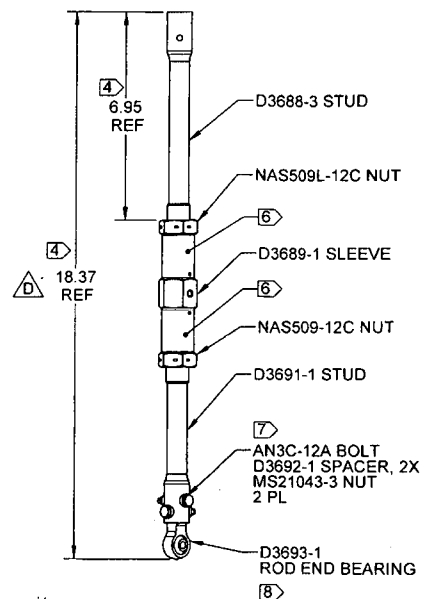
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ITEM	QTY -049	PART NUMBER	DESCRIPTION
1	X	D3684-049	AFT LEG ASSEMBLY
2	1	D3688-3	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



D3684-049 AFT LEG ASSEMBLY

RELEASED
2010-03-15

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- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 2.86 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3684	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
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